ACCUPAN HIGH SPEED 
BUN SYSTEM

• New Vector Technology Improves Scaling, Decreases Dough Shear, and Increases Vacuum System Efficiency
• The Latest Automated Technology for High Speed Bun Roll Production
• Highest Speed Bun System Available, Over 5,000 Dozen Per Hour
• Standard for Bun Production Around the World for Over 20 Years

FEATURES & BENEFITS

Design Innovations
• Extrusion divider offers the most accurate scaling available with superior product quality
• Hinged spiral tunnel rounder bars with gas spring assist for improved rounding symmetry and easier access for sanitation and maintenance while eliminating sticking
• Servo rotary gate precisely times transfer between the zig-zag and the proofer tray at high production speeds and eliminates high maintenance associated with pneumatic actuators
• Electronic synchronization between the divider and proofer allows accurate timing without high maintenance chain or shaft drives
• Magnetic pan indexing provides the non-stop precision required for high-speed production and eliminates the mechanical indexer assembly, reducing maintenance costs and opening up the panning area for easy access

Design Flexibility
• Handles a variety of production requirements with 4, 6, and 8 across configurations
• A variety of layout configurations including standard and reverse feed, right or left hand controls and multiple proofer configurations allows the Accupan High Speed to fit in most production layouts
# ACCUPAN HIGH SPEED BUN SYSTEM

## MECHANICAL FEATURES

- **High Speed Bun Divider**
  - Stainless steel frame and hopper for durability and corrosion resistance
  - Precision stainless steel tunnel housing for durability and minimum dough flow resistance
  - Dual auger design for gentle dough handling at high throughputs
  - New high efficiency Eurodrive gearmotors
  - 3” (76 mm) Waukesha stainless steel metering pump for precise flow control
  - Patented UHMW free-flow manifold for even dough distribution
  - Patented diaphragm valves with position indicators for maximum port-to-port flow control

- **Rounder**
  - Poly-slick rounder belt
  - Hinged rounder bar frame with gas spring assist for easy cleaning and maintenance access
  - UHMW spiral tunnel rounder bars
  - Direct drive rounder belt
  - Cantilevered rounder frame design for quick belt changes
  - Independently driven UHMW kicker roller

- **Proofer**
  - UHMW zig-zag board and lane guides
  - Servo driven rotary gate dough ball transfer system
  - Pneumatic pulse sifter with linear motion at zig-zag and moulder areas
  - Stainless steel flour catch pan with integral zig-zag design that is adaptable to optional automatic flour recycling systems
  - Heavy duty proofer trays with stainless steel frame, non-stick analytic plastic snap-in trays
  - Three 10’ (3048 mm) section stainless steel tubular frame proofer in either stretched or stacked configuration
  - Hinged catch pans on underside of proofer with safety key latch
  - Single action flapper gate controls the drop from the proofer into the sheeter

- **Sheeter/Moulder/Panner**
  - 6” (152 mm) diameter grooved steel sheeter roller
  - Adjustable 6” (152 mm) diameter smooth sheeter roller with non-stick coating
  - Open design sheeter drive for easy maintenance
  - Cantilevered moulder belt fame design for easy belt access
  - Synthetic/cotton-topped moulder belt for flour retention and stretch resistance
  - Pneumatic driven hot dog gate with PLC control for on-the-fly adjustment
  - Magnetic pan indexer for precise panning at low and high production speeds
ELECTRICAL FEATURES

Equipped with two NEMA 4 rated operator control stations:
- On the side of the tower
- At the moulder

Allen Bradley PanelView Plus 1250 touch keypad operator interface with alarm messages and recipe management on operator panel to control:
- Divider
- Rounder belt speed
- Rotary gate speed
- Pulse zig-zag flour sifter speed
- Proofer speed
- Sheeter roller speed
- Moulder belt speed
- Pulse moulder sifter speed
- Hot dog gate phasing and speed
- Magnetic pan indexer
- Flour recovery (if equipped)

Allen Bradley pushbuttons operator panel for:
- Two-button start
- Stop
- Emergency stop
- MCR reset

NEMA 12 remote electrical enclosure (stainless steel) including:
- Main disconnect switch
- Full voltage magnetic NEMA rated starters
- Allen Bradley CompactLogix PLC control
- Allen Bradley PowerFlex inverters

OPTIONS

Mechanical Options
- DoFlow Dough Developer
- Hopper block-off slide
- Reverse axis rounder
- Chilled rounder bed
- Aluminum spiral tunnel rounder bars with Teflon coating
- Mesh cup proofer trays with stainless steel frame
- Additional proofer sections
- CE compliant design package
- UHMW moulder board assemblies
- Twin roll cutter
- Moulder board hoist systems
- Zig-zag vacuum flour reclaim system
- Pan dust collector
- Multi-Vac Flour Recycling System
- Magnetic pan pre-indexer conveyor
- Additional stainless steel proofer support legs
- Zig-Zag Cover
- Roll imprinters

Electrical Options
- Panel modem option
- Product memory increase for over 40 products
- Panel air conditioner in lieu of Exair panel cooler
- Allen Bradley PanelView upgrade
- Allen Bradley PLC upgrade
- Panel air conditioner in lieu of Exair panel cooler

SPECIFICATIONS

<table>
<thead>
<tr>
<th>Configuration</th>
<th>Divider Type</th>
<th>Speed Range*</th>
<th>Maximum Throughput*</th>
<th>Scaling Range</th>
</tr>
</thead>
<tbody>
<tr>
<td>Accupan High Speed 4</td>
<td>4 across</td>
<td>HBD 40 to 145</td>
<td>7,500 lb./hr. (3402 kg/hr.)</td>
<td>7/8-6 oz. (25-170 g)</td>
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<tr>
<td>Accupan High Speed 6</td>
<td>6 across</td>
<td>HBD 40 to 145</td>
<td>11,000 lb./hr. (4990 kg/hr.)</td>
<td>7/8-6 oz. (25-170 g)</td>
</tr>
<tr>
<td>Accupan High Speed 8</td>
<td>8 across</td>
<td>HBD 40 to 145</td>
<td>15,000 lb./hr. (6804 kg/hr.)</td>
<td>7/8-6 oz. (25-170 g)</td>
</tr>
</tbody>
</table>

*Throughput, maximum speed and scaling range are dependent on several factors including dough condition, product configuration and other associated equipment. Gearmotors are sized to meet a specific production range.